



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73914**

Monday, September 19, 2011 10:07:33 AM

Page 2

Item ID: D3822-3KGY

Accept

Setup Start

Revision ID:

Stop

Item Name: Vertical Tunnel, Aft Center-Grey

Start Date: 9/19/2011 Start Qty: 2.00

Required Date: 9/23/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  Thermoform Thermoforming Machine	<b>Memo</b> 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA027 using tool DT9072 Dwg Rev: <u>C</u> Folio Rev: <u>B</u>	0.00  0.00				x2			Wh 11/12/21
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  <b>Memo</b> Visually inspect part for proper formation and texture	0.00  0.00				x2			Oh 11/12/21
130  QC Quality Control	QC8- Inspect parts - second check  <b>Memo</b>	0.00  0.00							8 11/12/21

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 73914**

Page 3

Monday, September 19, 2011 10:07:33 AM

Item ID: D3822-3KGY

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, Aft Center-Grey

Start Date: 9/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x2

DH  
11/17/22

150

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

x2

DH  
11/12/22

160

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

8 11/12/23

⑨

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 73914**

Monday, September 19, 2011 10:07:33 AM

Page 4

Item ID: D3822-3KGY

Accept

Setup Start

Revision ID:

Stop

Item Name: Vertical Tunnel, Aft Center-Grey

Start Date: 9/19/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg & Stock Location: 156

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 12/01/02

M.L.J 11/12/29

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



# Picklist Print

Monday, September 19, 2011 10:07:30 AM

Page 1

Work Order ID: 73914



Parent Item: D3822-3KGY



Parent Item Name: Vertical Tunnel, Aft Center-Grey

Start Date: 9/19/2011

Required Date: 9/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD-verified by:EC  
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	436.3796	5.25	10.50525			



Kydex steel grey



Location

therm

Loc Qty

436.3796282

436.379628

Loc Code

~~111807~~

119476

10.50525 sf Rt

WLC  
11/12/22

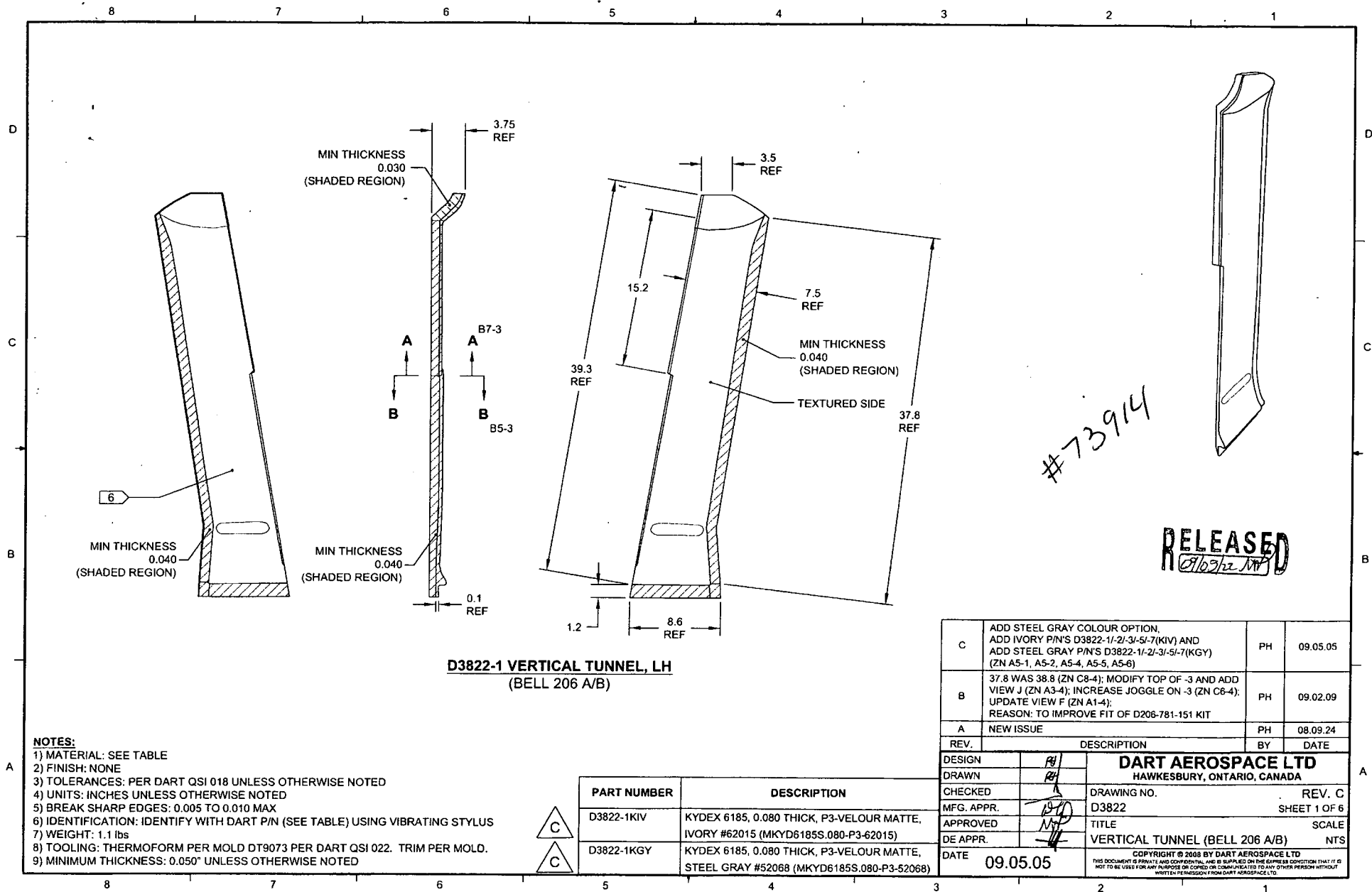
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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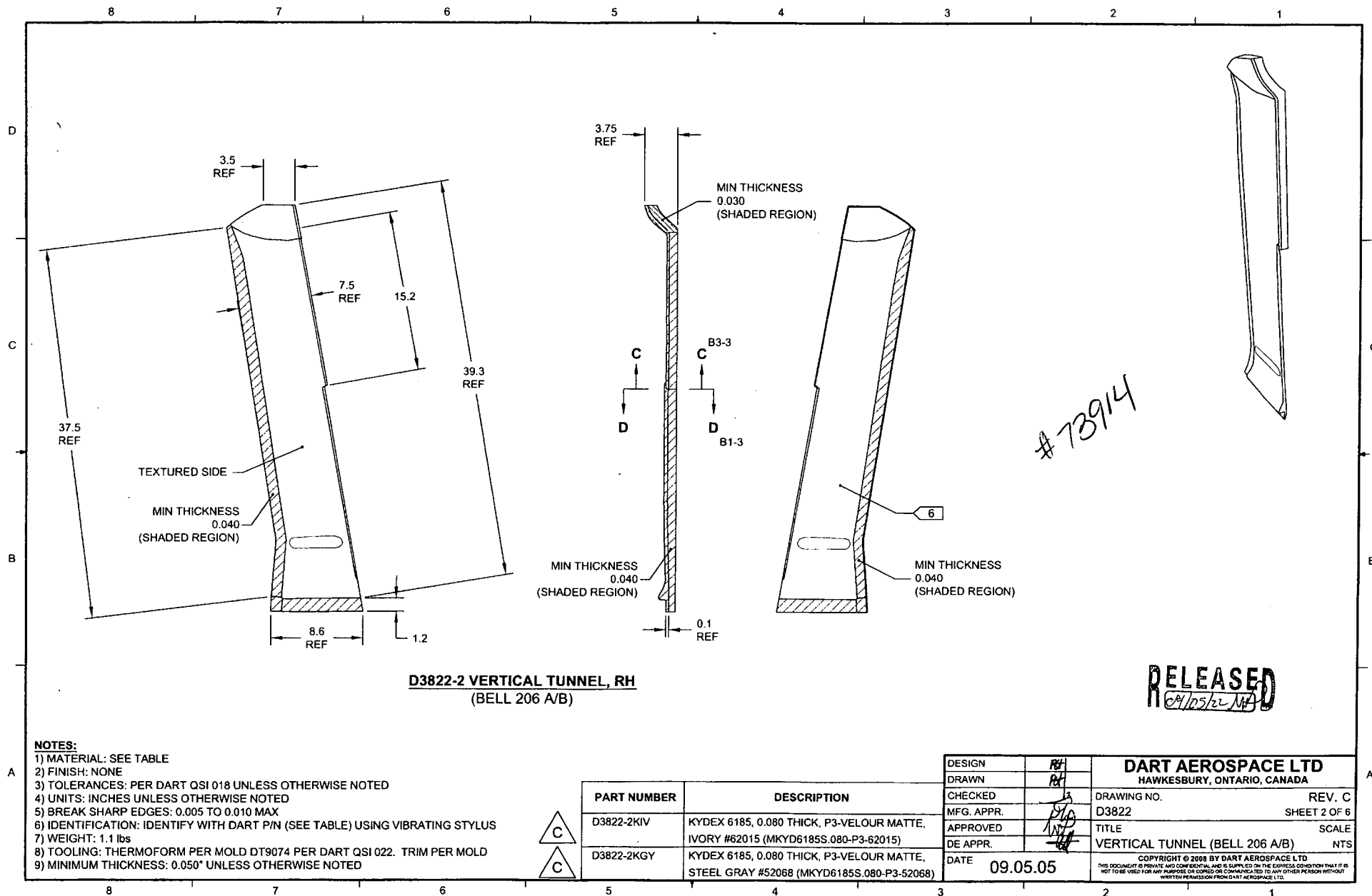
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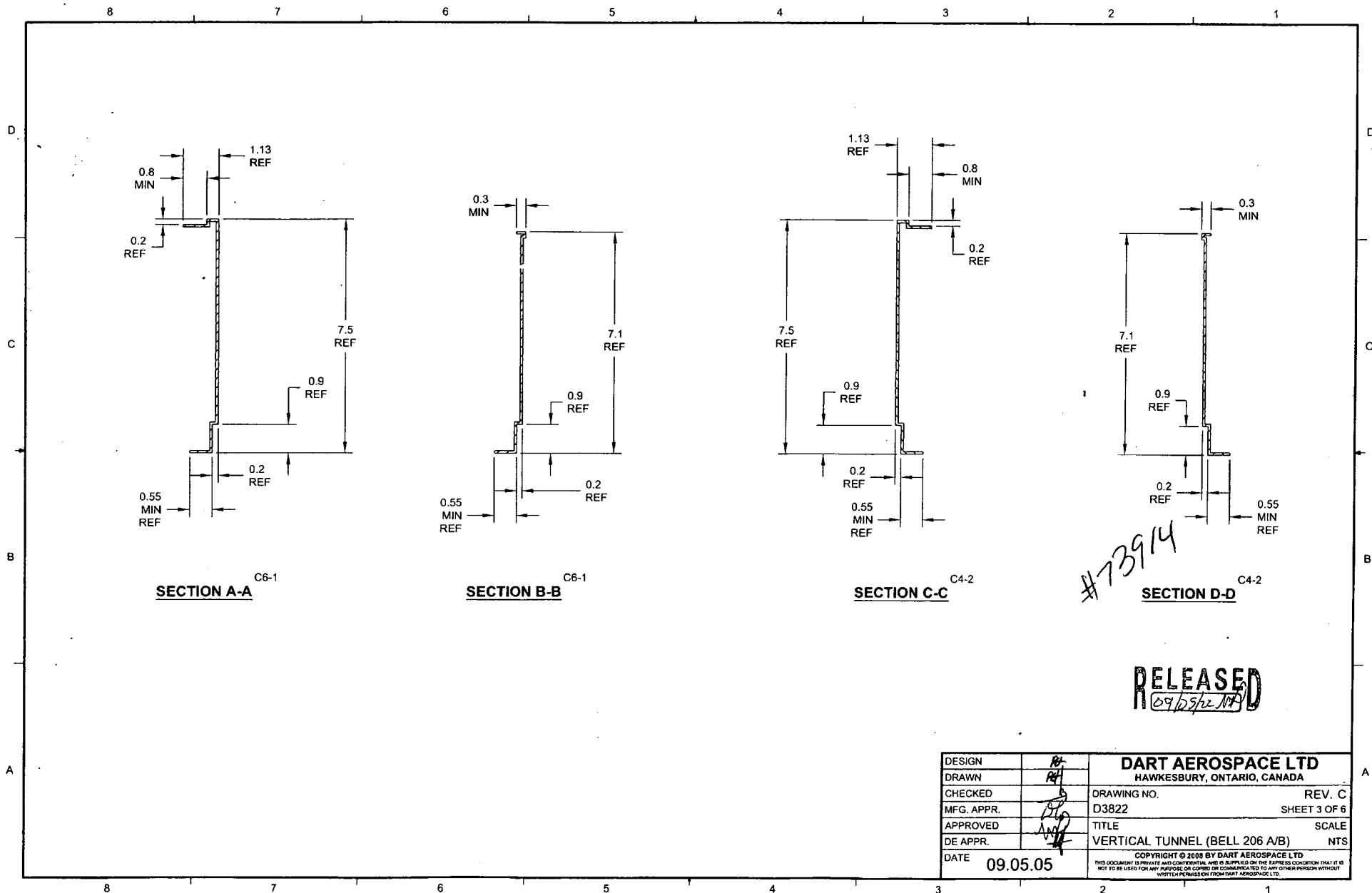
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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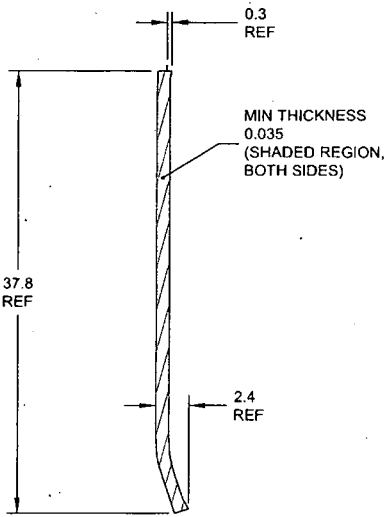
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D

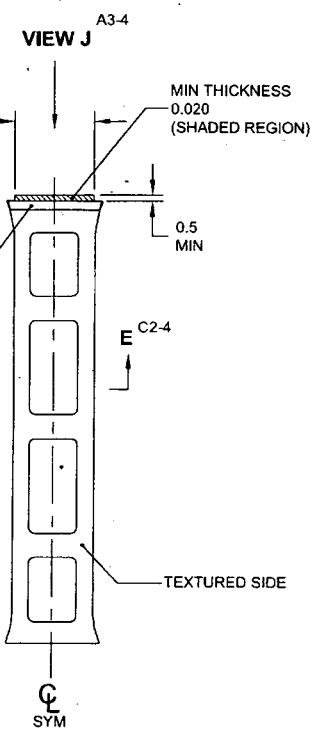
C

B

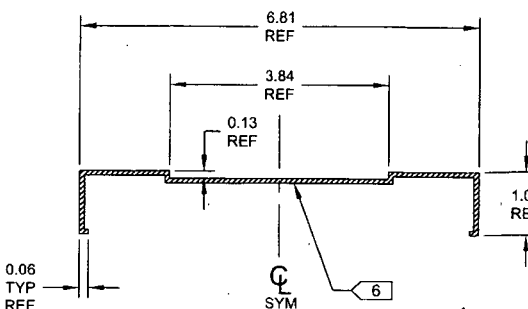
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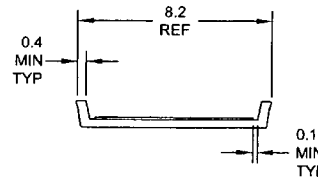
VIEW F  
A1-4



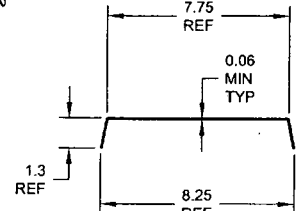
**D3822-3 VERTICAL TUNNEL, AFT CENTER**  
(BELL 206 A/B)



**SECTION E-E**  
SCALE 5X



**VIEW J**  
SCALE 2X



**VIEW F**  
SCALE 2X  
(ROTATED 90° CW)

**RELEASED**  
9/65/22 M

- NOTES:**
- 1) MATERIAL: SEE TABLE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
  - 7) WEIGHT: 1.1 lbs
  - 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
  - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	RE	<b>DART AEROSPACE LTD</b>
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3822
MFG. APPR.		REV. C
APPROVED		SHEET 4 OF 6
DE APPR.		TITLE VERTICAL TUNNEL (BELL 206 A/B)
DATE	09.05.05	SCALE NTS
COPYRIGHT © 2008 BY DART AEROSPACE LTD		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPARISONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

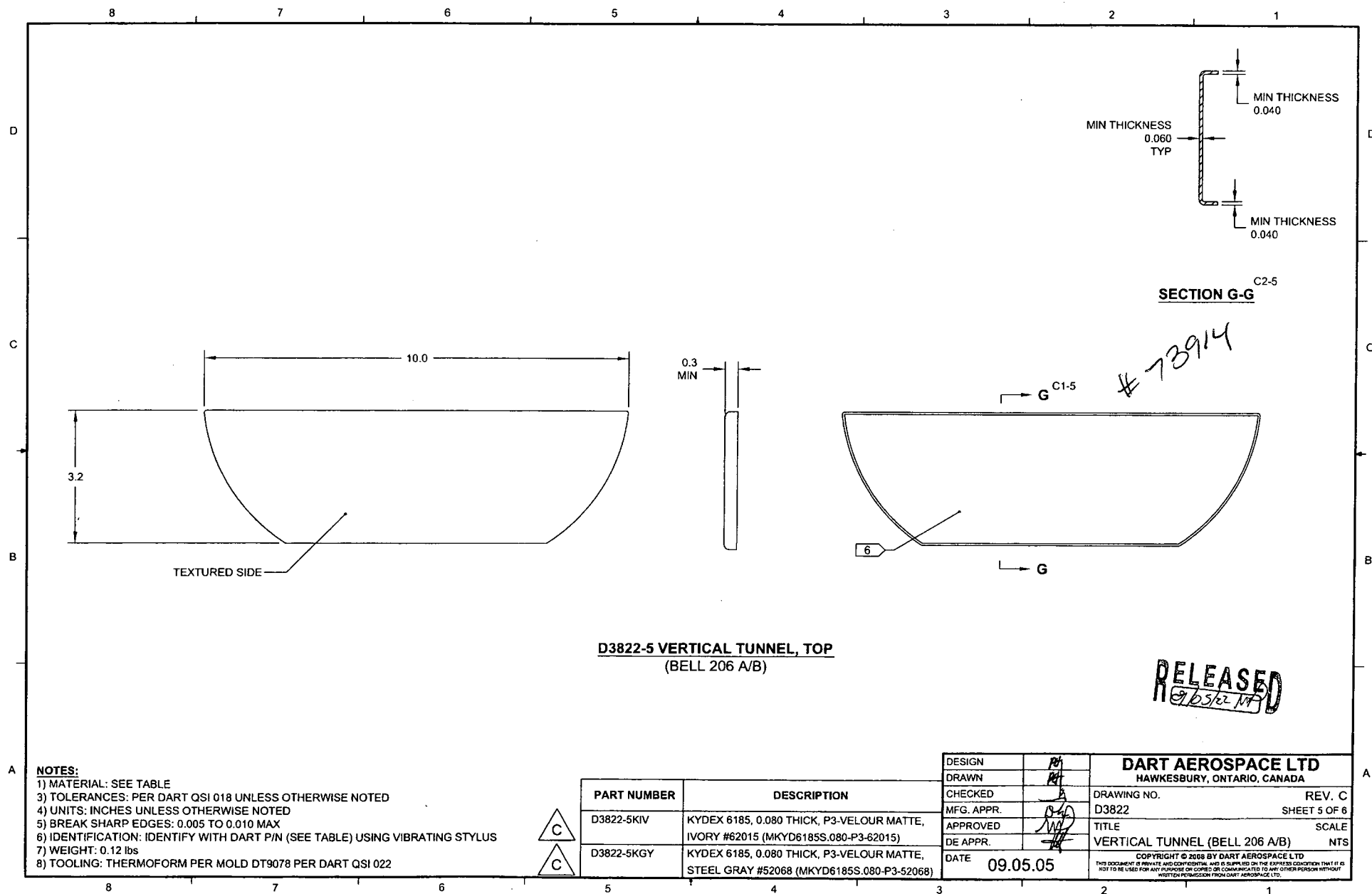
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**NOTE:** Date & initial all entries



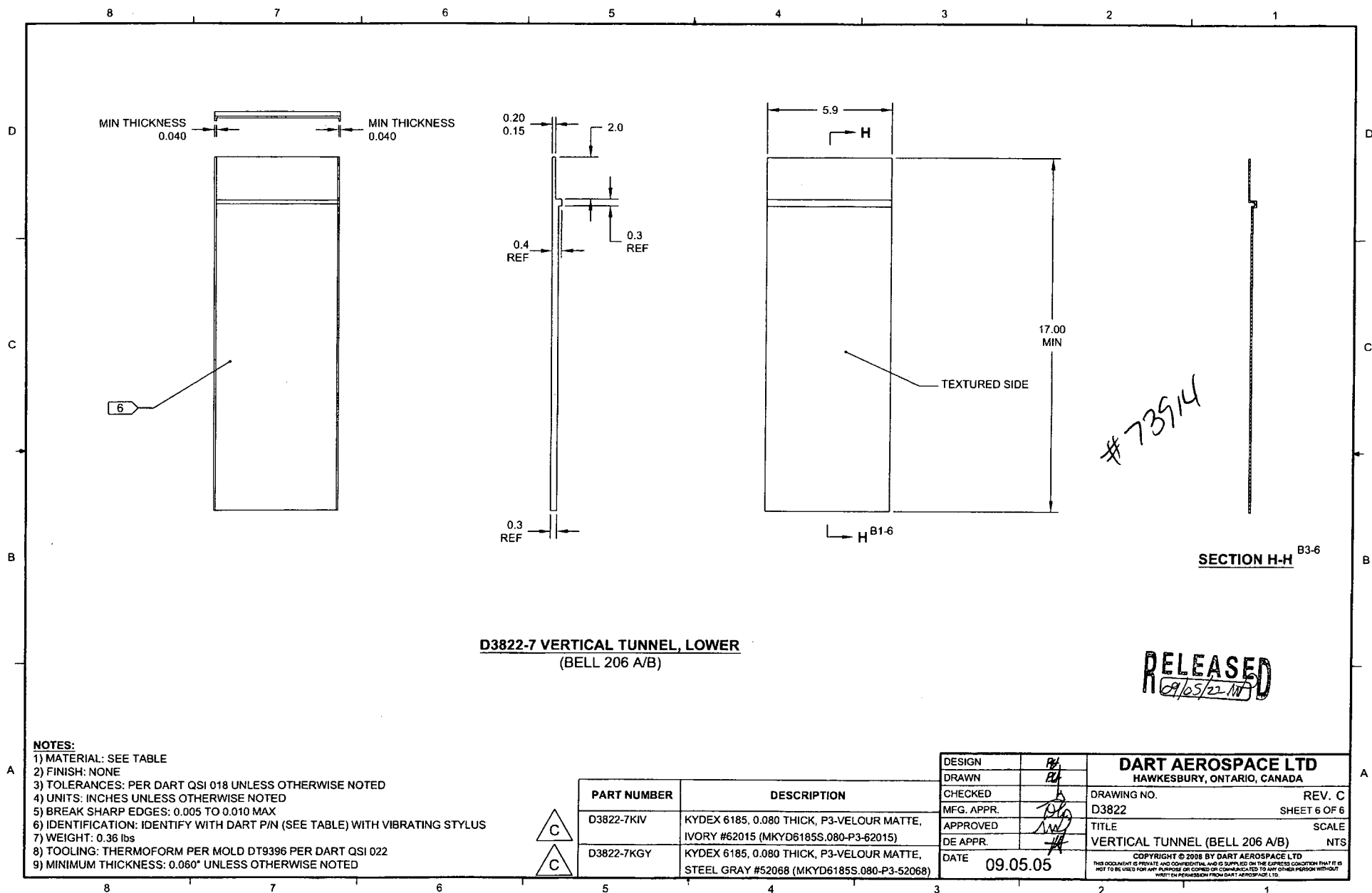
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	73914
<b>Description:</b> Vertical Tunnel, Aft Center		<b>Part Number:</b>	D3822-3KIV/KGY
<b>Inspection Dwg:</b> D3822	<b>Rev:</b> C	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

**Measured by:** \_\_\_\_\_

**Date:** \_\_\_\_\_

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min					
0.020	Min					
0.035	Min					
0.4	Min					

**Measured by:** \_\_\_\_\_



**Date:** \_\_\_\_\_

**Audited by:** \_\_\_\_\_

**Date:** \_\_\_\_\_

**Prototype Approval:** \_\_\_\_\_ N/A

**Date:** \_\_\_\_\_ N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	73914
<b>Description:</b> Vertical Tunnel, Aft Center		<b>Part Number:</b>	D3822-3KIV/KGY
<b>Inspection Dwg:</b> D3822	<b>Rev:</b> C	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

**Measured by:** DR **Date:** 11/12/21

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.079"	✓		CAL TH-DT	
0.020	Min	0.073"	✓		CAL TH-DT	
0.035	Min	0.053"	✓		CAL TH-DT	
0.4	Min	0.28"		✓	Verandh-02	OK P 11.12.22 BS1042

**Measured by:** DR **Date:** 11/12/21

**Audited by:** S **Date:** 11/12/23

**Prototype Approval:** N/A **Date:** N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	